

Date Wednesday, 15/08/2007 4:09:55 PM
 User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKIDTUBE		
Job Number	: 33973					
Estimate Number	: 10366					
P.C. Number	: N/A			Part Number	: D412742013	
This Issue	: 15/08/2007		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: N/A UNDER REVIEW	
First Issue	: N/A		Type	: LANDING GEAR		
Previous Run	: 33972			Project Number	: N/A	
Written By				Drawing Revision	: N/A	
Checked & Approved By				Material	: N/A	
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DS19336 JLM			Due Date	: 10/09/2007	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	KS 07-08-30 <i>Er 07/09/12</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003	
2.0	33973A	FLOAT SKID ASSEMBLY	<i>Er 07/09/12</i>
		Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B <u>33973A</u>	
3.0	D2571	Saddle, Fwd, Out	<i>Er</i> Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2571 Saddle Fwd Outside <u>032165</u>
4.0	D2572	Saddle, Fwd, In	<i>Er</i> Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2572 Saddle Fwd Inside <u>031720</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

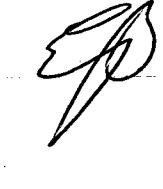
Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D2573	Saddle, Aft, Out
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2573 Saddle Aft Outside <u>B31721</u>	
6.0	D2574	Saddle, Aft, In
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2574 Saddle Aft Outside <u>B32168</u>	
7.0	D2747	Set Screw
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	4 D2747 Bolt <u>B33470</u>	
8.0	D2876	Saddle Spacer
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D2876 Saddle Spacer <u>B31227</u>	
9.0	D2877	Saddle Spacer
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D2877 Saddle Spacer <u>B32104</u>	
10.0	D34031	Bushing
		
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	16 D3403-1 Bushing <u>B33562</u> <u>8x</u> <u>B33286</u> <u>8x</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :	
11.0	D34033	Bushing	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	8 D3403-3	Bushing	<u>b32889</u>
12.0	D3405041	Lug Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D3405-041	GHW Lug	<u>b32890</u>
13.0	D3405043	Lug Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D3405-043	GHW Lug	<u>b32891</u>
14.0	AN4C6A	Bolt	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	16 AN4C6A	Bolt	<u>M104603</u>
15.0	AN4C46A	BOLT	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	4 AN4C46A	Bolt	<u>M119529</u>
16.0	AN4C52A	BOLT	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	8 AN4C52A	Bolt	<u>M100340</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
17.0	AN6C12A	BOLT
		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		<u>M104289</u>
8 AN6C12A Bolt		
18.0	AN960C416L	WASHER
		
Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		<u>M104936</u>
32 AN960C416L Washer		
19.0	AN960C616L	WASHER
		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		<u>M18822</u>
8 AN960C616L Washer		
20.0	AN960C716L	WASHER
		
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		<u>M104093</u>
16 AN960C716L Washer		
21.0	MS210434	Nut
		
Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		<u>M105115</u>
29 MS21043-4 Nut		
		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
22.0	NAS1515H4L	WASHER
		<i>GP</i>
	Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)	
	Pick:	
	Qty Part Number	Description
	32 NAS1515H4L	Washer
		<i>M10521 B1X M105408@</i>
23.0	NAS1515H6L	WASHER
		<i>GP</i>
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	Pick:	
	Qty Part Number	Description
	8 NAS1515H6L	Washer
		<i>M18918</i>
24.0	NAS1515H7L	WASHER
		<i>GP</i>
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)	
	Pick:	
	Qty Part Number	Description
	16 NAS1515H7L	Washer
		<i>M100727</i>
25.0	D3407041	Tow Ring
		<i>GP</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number	Description
	1 D3407-041	TOW RING
		<i>B30394</i>
26.0	D34173	Washer
		<i>GP</i>
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number	Description
	2 D3417-3	WASHER
		<i>B33519</i> <i>GP 07/09/10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33973

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
27.0	D34561	washer
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	B 33276 -
28.0	AN4C7A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Bolt	D 33276 -
	Batch: 1101427 -	
29.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	For 09/09/12
30.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Identify and pack for shipping as per PPP D412-742-018	
	Location: D	C
31.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	10/09/13
	Job Completion	
		W 09/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
 User: Linda Lacelle

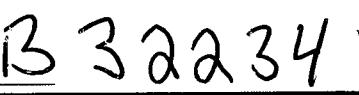
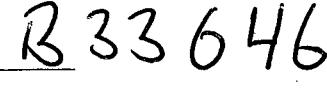
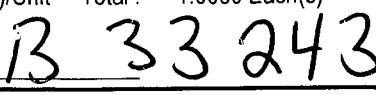
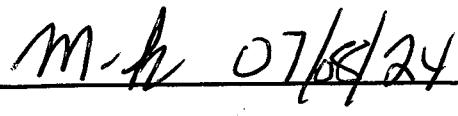
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKID ASSEMBLY		
Job Number	: 33973A			Part Number	: D412742043	
Estimate Number	: 10756			Drawing Number	: D3391 REV F	
P.C. Number	: N/A			Project Number	: N/A	
This Issue	15/08/2007	S.O. No.	: N/A	Drawing Revision	: F	
Prsh Rev.	: NC			Material	: N/A	
First Issue	: N/A			Due Date	: 10/09/2007	
Previous Run	: 33972A			Qty:	1	Um: Each
Written By	: 					
Checked & Approved By	: 					
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM			Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		
				Est Rev:C 07-05-28 As per Rev F JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003	
2.0	D3391023	Mid Tube Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-023 Mid Tube Assembly 	
3.0	D3391025	Aft Tube Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch 1 D3391-025 Aft Tube Assembly 	
4.0	D35641	WEARSHOE	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch:  	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :	
5.0	D35643	WEARSHOE	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	<i>m-k</i>
		WEARSHOE	<i>B 33764</i>
		Batch:	
6.0	D35645	WEARSHOE	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	<i>m-k</i>
		WEARSHOE	<i>B 33802</i>
		Batch:	
7.0	D35661	GASKET	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	<i>m-k</i>
		GASKET	<i>B 33458</i>
		Batch:	
8.0	D35665	GASKET	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	<i>m-k</i>
		GASKET	<i>B 33483</i>
		Batch:	
9.0	AN3C4A	BOLT	
		Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)	<i>m-k</i>
		BOLT	<i>M 105143</i>
		Batch:	
10.0	AN3C6A	BOLT	
		Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)	<i>m-k</i>
		BOLT	<i>M 103693</i>
		Batch:	
11.0	AN3C7A	BOLT	(X)
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	<i>m-k 07/08/24</i>
		BOLT	<i>M 103668</i>
		Batch:	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch:

M 10 5143

M-A

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



IX

Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M 10 4161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/291 M 10 4989
Expiry date: 08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M 10 4251
A/R Sikaflex-241/291 M 10 4989
Expiry date: 08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

07/08/04

M-A

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 21/08/04

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

1PP 33973A 07/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:10:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33973A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/15/13 (1)

Job Completion



U 8/15/13

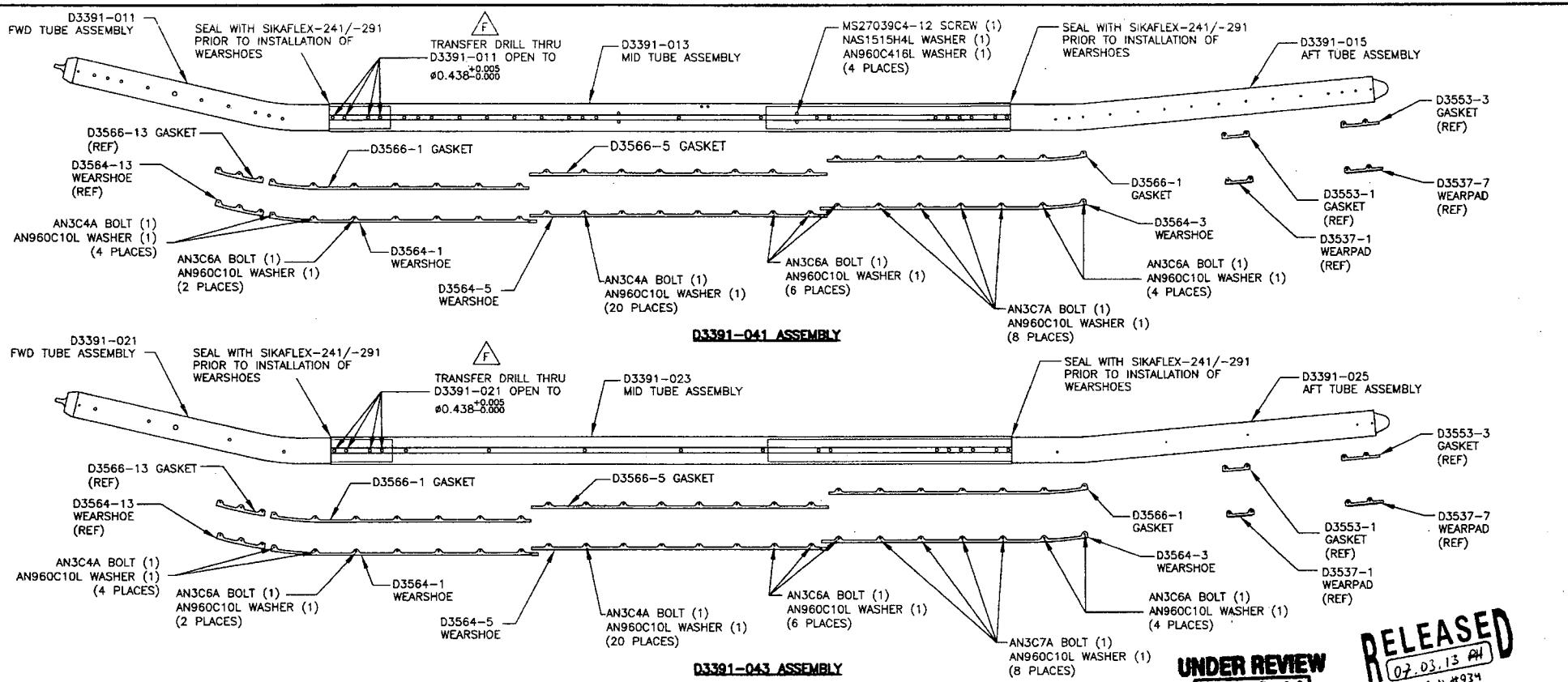
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASER
07.07.30 PH
07.07.30 DC
CHANGING INSERTS

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	043	D3391-041	FLOAT SKIDTUBE ASSEMBLY
X	1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	1	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (.0250-.0257) FOR WEARSHOE INSERTS. C'SINK .0391/.0425 x 100° AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

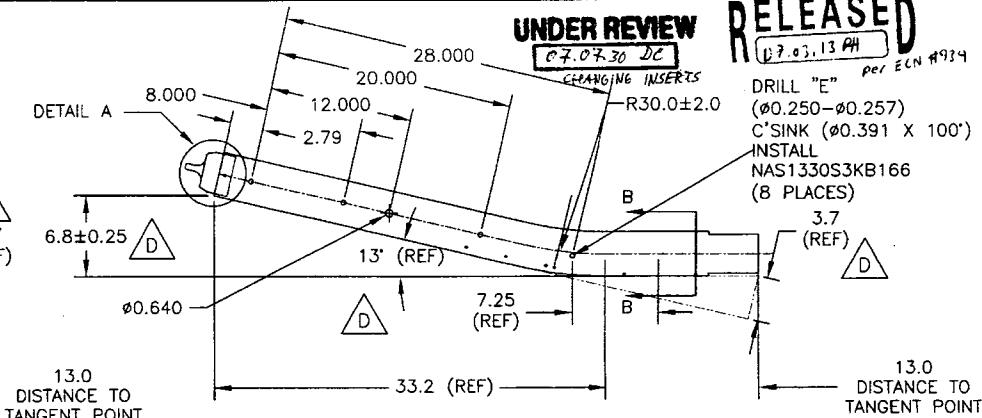
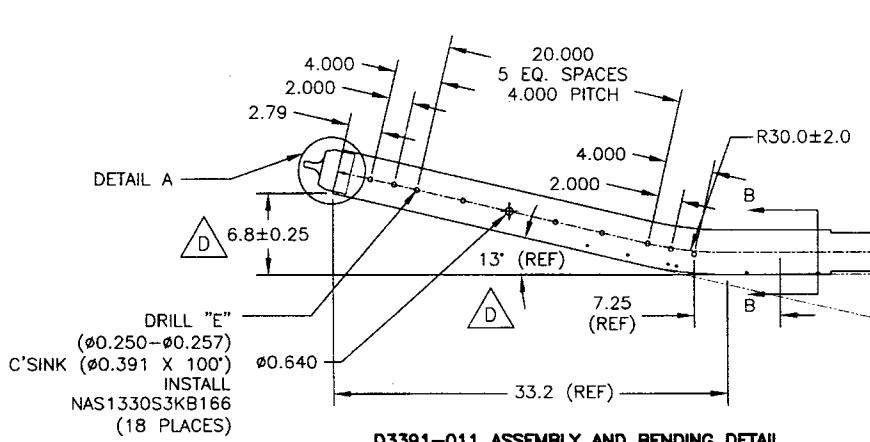
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

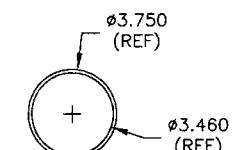
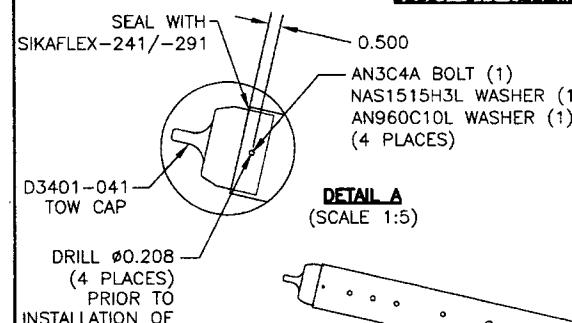
DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3391	REV. F SHEET 1 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE NTS	

RELEASED
07.07.30 DC
07.03.13 PH

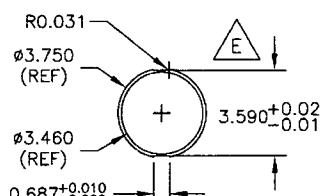
per ECN #934



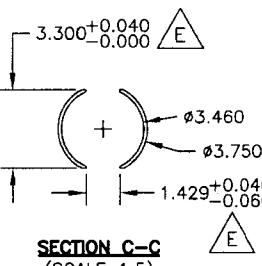
D3391-011 ASSEMBLY AND BENDING DETAIL



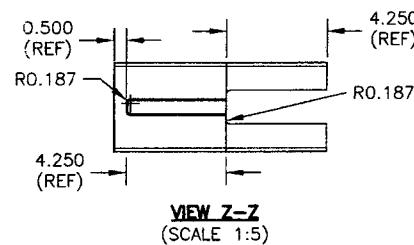
SECTION E-E
(SCALE 1:5)



SECTION D-D
(SCALE 1:5)

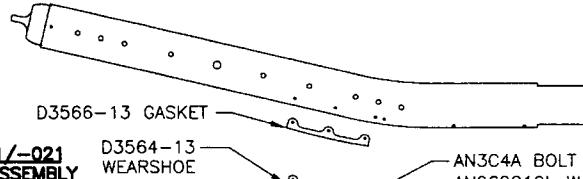


SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)

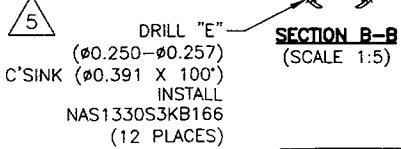
D3391-011/-021 WEARSHOE ASSEMBLY



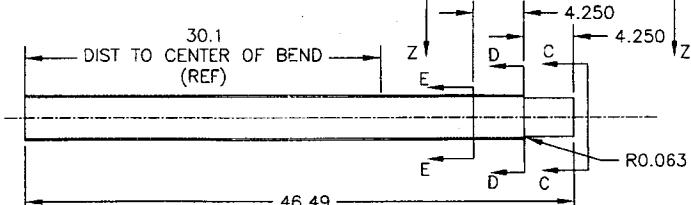
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(6 PLACES)

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)



SECTION B-B
(SCALE 1:5)

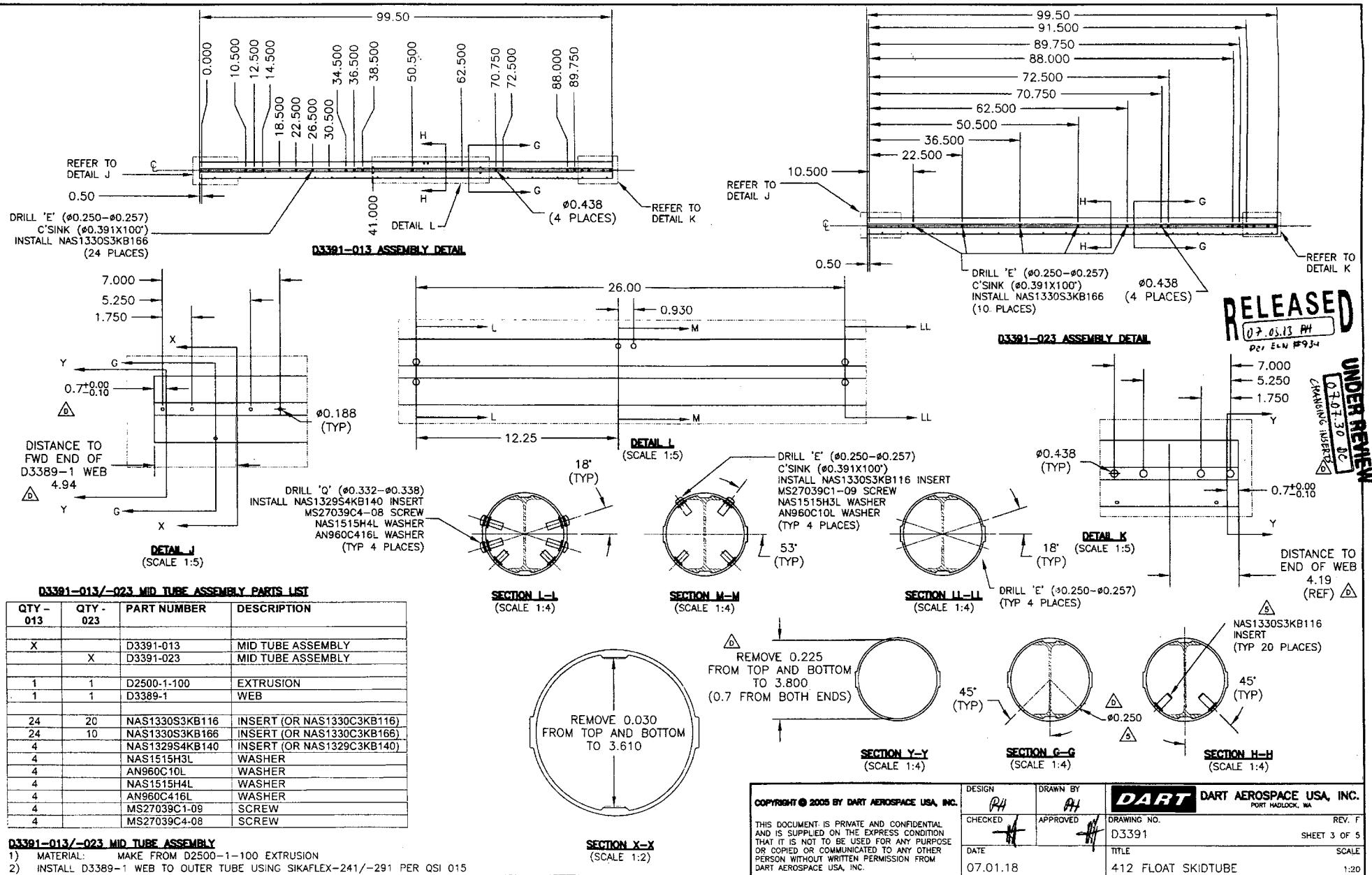


D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE USA, INC. PORT HEDLOCK, WA
CHECKED <i>PH</i>	APPRVED <i>PH</i>	DRAWING NO. D3391	REV. F SHEET 2 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE	1:10

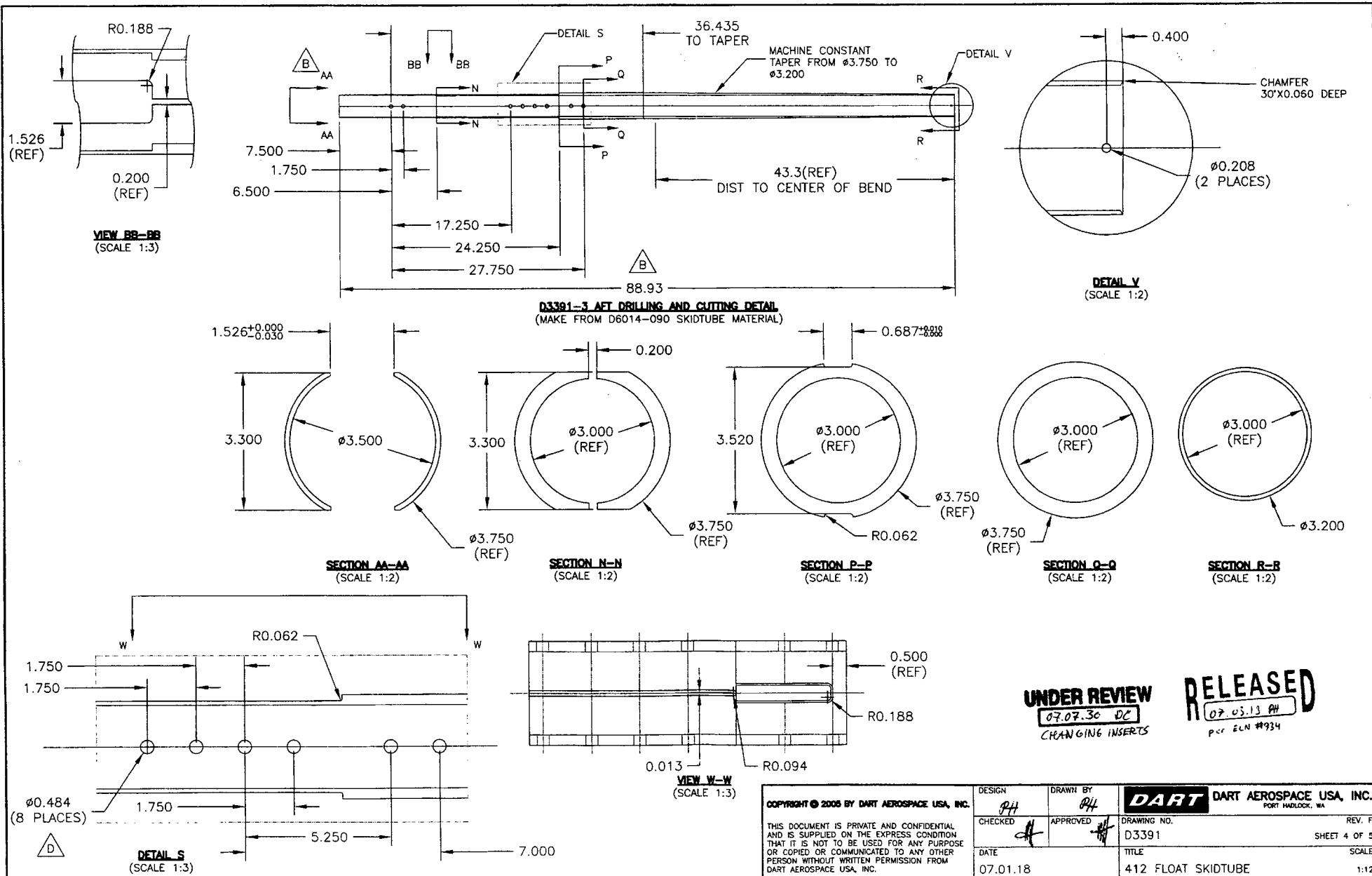
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

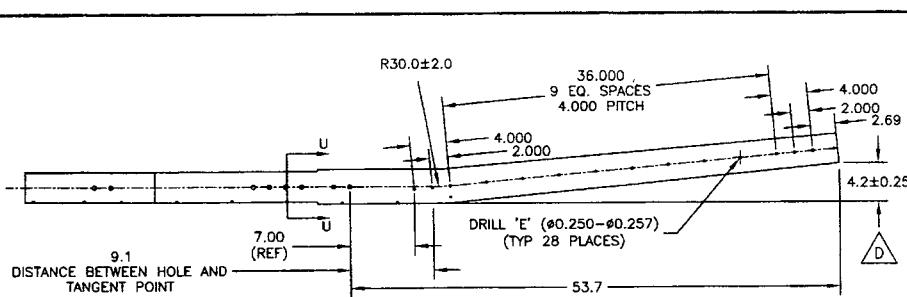
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.



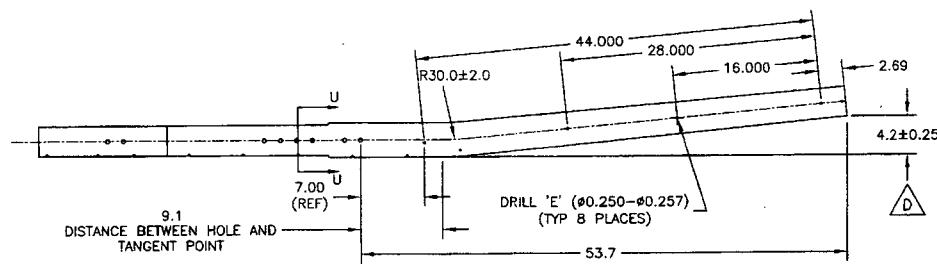
D3391-013/-023. MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

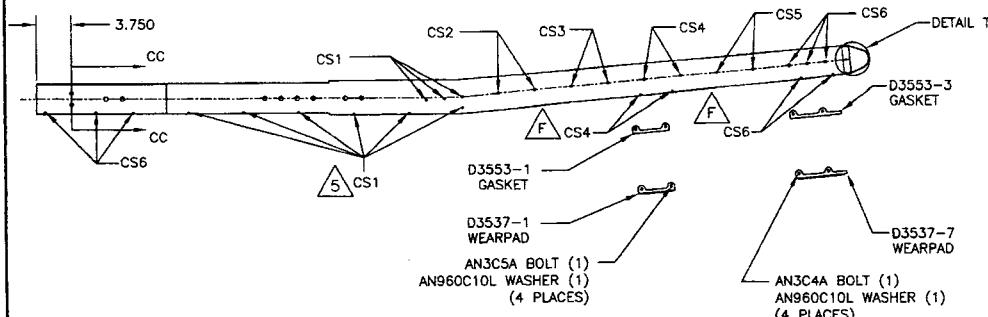




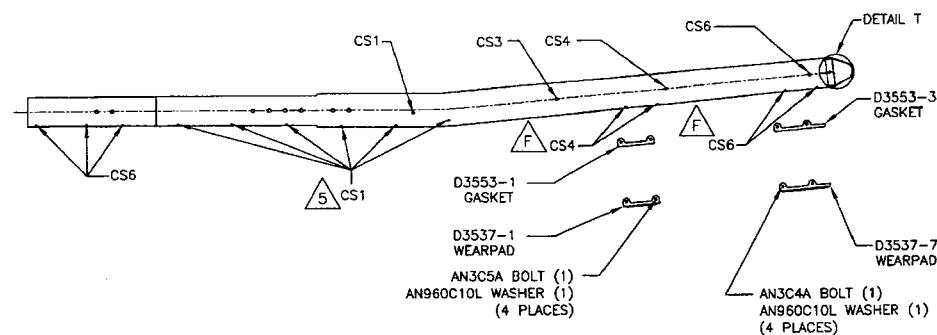
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



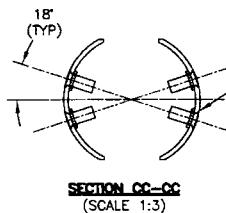
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

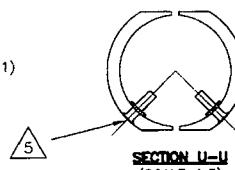
QTY-015	QTY-025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
X	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	1	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	1	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4	2	Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4	2	Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166



SECTION CC-CC
(SCALE 1:3)

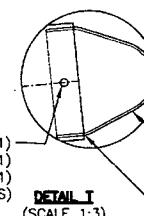


SECTION U-U
(SCALE 1:3)

DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100')
NAS1330S4KB151 INSERT (1)
(4 PLACES)

AN3C4A BOLT (1)
AN1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)

D2646 AFT CAP



DETAIL T
(SCALE 1:3)

SEAL WITH
SIKAFLEX-241/-291

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN

PH

DRAWN BY

PH

DRAWN NO.

D3391

REV. F

DATE

07.01.18

TITLE

412 FLOAT SKIDTUBE

RELEASED
07.03.13 PH
PV ECN #734

UNDER REVIEW
07.07.30 DC
CHANGING INSERTS

AN3C4A BOLT (1)
AN1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH

PV ECN #734

07.07.30 DC

CHANGING INSERTS

AN3C4A BOLT (1)

AN1515H3L WASHER (1)

AN960C10L WASHER (1)

(2 PLACES)

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
(SCALE 1:3)

SECTION U-U
(SCALE 1:3)

SECTION CC-CC
(SCALE 1:3)

RELEASER

07.03.13 PH